Memo

Quality Control

	-								•
W/O:			W	ORK ORDER CHANG	ES		***************************************		•
DATE	STEP	PRC	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	_ Date: _	
	Re	esolution:	Dispositi	on:	_ QA: N/C CI	osed:		Date: _	
NCR:		\	WORK OR	DER NON-CONFORMA	ANCE (NCF	1)			
DATE	STEP	Description of NC Corrective Action			ion B	Verific	cation		Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector
								POTOTOTOTOTOTOTOTOTOTOTOTOTOTOTOTOTOTOT	
									!

Work Order ID 683	46
-------------------	----

Tuesday, April 12, 2011 10:07:41 AM



Page 2

Item ID:

D3405-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Lug Assembly

Start Date:

4/12/2011

Start Qty: 12.00

Operation

Description

NC BRAKE

Required Date: 4/18/2011

Reg'd Qty: 12.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Date:

Run

Start

Stop

Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Memo

1-Deburr 2-Form using DT8204 as per Dwg D3405

3- use DT9681 to check if correct forming

Set Up/ **Run Hours**

SPC (Y/N):

0.00

0.00

SB 11/04/29

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Stamp Number

140

Quality Control

QC5- Inspect part completeness to step on W/O

150

Large Fab

Large Fab

Large Fab

Memo

Memo

0.00

0.00

Weld as per Dwg D3405 use DT8484

Identify as D3405-041

EL 11-5-25

	•								
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	on:	_ QA: N/C Cld	osed:		Date: _	
NCR:		1	WORK ORD	ER NON-CONFORMA	ANCE (NCR)			
DATE	CTED	Description of NC Corrective Action			ion B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
						·			
				· · · · · · · · · · · · · · · · · · ·					
I	1	I .			[1		1	1

Work Order ID 68346

Tuesday, April 12, 2011 10:07:41 AM



Page 3

Item ID:

D3405-041

Accept



Setup Start



Revision ID:

Item Name:

Lug Assembly

Start Date:

Required Date: 4/18/2011

4/12/2011

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

0.00

0.00

Tooling:

Set Up/

Run Hours

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop

Sequence ID/ Work Center ID

160

QC

Quality Control

Operation Description

QC9- Inspect visual per QSI004- Fusion Welds

Memo

Tool ID

Tool# Plan

Code

Accept Oty

Reject **Qty**

Reject Insp. Number Stamp

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Sules 66

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Memo

START TIME:

FINISH TIME:

0.00

12 11-5-27.

Powdercoat

180

Powder Coating

OVEN TEMPERATURE

0.00

	-												
W/O:			V	ORK ORDER CHA	ANGES								
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
					•				Frod Wgi				
		<i>*</i>		, .	,								
Part No	:	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	A:	_ Date: _				
Res		esolution:	tion: Disposition: Q										
NCR:			WORK OR	DER NON-CONFO	RMANCE	(NCR)						
DATE	OTED	Description of NC	Corrective Action Section B			\		cation	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Descrip	tion	Sign & Date		tion C	Chief Eng	QC Inspector			
							_						
·						,							
					r					٠.			
							*						

Work Order ID 68346

Page 4

Tuesday, April 12, 2011 10:07:41 AM

Item ID:

D3405-041

Accept



Setup Start



Revision ID:

Item Name:

Lug Assembly

Start Date:

Required Date: 4/18/2011

4/12/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Sequence ID/

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Stop

Work Center ID

190

QC

Quality Control

Operation Description

QC3-Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00

Qty

Accept

Reject Qty

Reject Insp. Stamp Number

200

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

210

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

	-							
W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							Prod Mgr	,
							-	
				_				
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes N	lo DQA:	Date: _	
	Re	esolution:	Disposition	on:	_ QA: N/C Clo	sed:	Date: _	
NCR:		•	WORK ORD	ER NON-CONFORM	ANCE (NCR)	ı		
		Description of NC	Corrective Action Sect	tion B	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
	1							

Picklist Print

Tuesday, April 12, 2011 10:07:48 AM

Work Order ID: 68346

Parent Item:

D3405-041

Parent Item Name: Lug Assembly



Start Date: 4/12/2011

Required Date: 4/18/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP A□05.09.01□New issue□KJ/JLM□

IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1		Manufactured	No			100	Each	30.0000	1	12 EZ	11-5	-25	- _y
				Location		Loc	Qty	Loc Code					
				WA030	(3)33		30		_				
M304S11GA		Purchased	No		67127	150	30 sf	6.0000	0.154	1.945263), C		
										, <u>P</u>	11-4-2		
304/316 0.125 Sheet				Location		Loc	Qty	Loc Code				75	3
				MAT020			6						
					116623		6		1	17494			

	•									•
W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·								
Part No	:	PAR #:	Fault Ca	tegory:	_ NCI	R: Yes I	10 DQ /	A :	Date:	
Resolution:			Disposit	N/C Clo	sed:		Date: _			
NCR:		V	VORK OR	DER NON-CONFORMA	ANCE	(NCR)			_	
DATE	STEP	Description of NC		Corrective Action Section	ion B		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
										
										1
				,						

DART AEROSPACE LTD	Work Order:	68344
Description: GHW Lug	Part Number:	D3405-1
Inspection Dwg: D3405 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

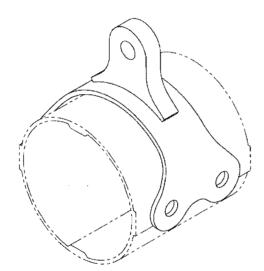
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006/-0.001	.439	15		V 1B02	
1.50	+/-0.030	1,507	>		ν	
1.750	+/-0.010	1,75}	X ⁴		ν	
6.751	+/-0.010	6.751	8		V	
8.00	+/-0.030	7.996	8		V	
0.125	+/-0.010	.117	7		V	
			-			
		**************************************	-			
				·		
_						
V-10-10-10-10-10-10-10-10-10-10-10-10-10-						

Measured by: B	Audited by:	Prototype Approval:	N/A
Date: 11-4- >つ	Date: [[[ou[27	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.11.28	New Issue P/O D3405-041	KJ/EC .	1
В	09.05.04	Dimensions update per Dwg Rev. B	KJ/DD 46	
			'77	7

W/O:	-		WC	RK ORDER CHANG	GES					
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	gory:	_ NCR	: Yes N	io DQ	A:	Date:	
	R	esolution:	Dispositio	1:	QA:	N/C Clo	sed:		Date: _	
NCR:		V	VORK ORDI	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC		ction B		Verific	ication Approva		Approval	
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	ion C	Chief Eng	QC Inspector
	,									
-										

TEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION			
1	X		D3405-041	LUG ASSEMBLY			
2		х	D3405-043	LUG ASSEMBLY			
11	1	1	D3404-1	GHW LUG			
12	1		D3405-1	GHW BRACKET			
13		1	D3405-3	GHW BRACKET			

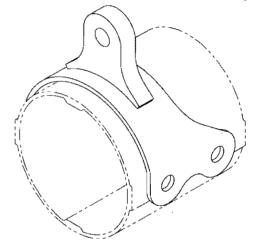


D3405-041 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WITHOUT NOTICE
WORK ORDER
NO. 48344

2

D



D3405-043 LUG ASSEMBLY (SKID TUBE SECTION SHOWN FOR REF ONLY)

NOTES: 1) MATERIAL: N/A 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER

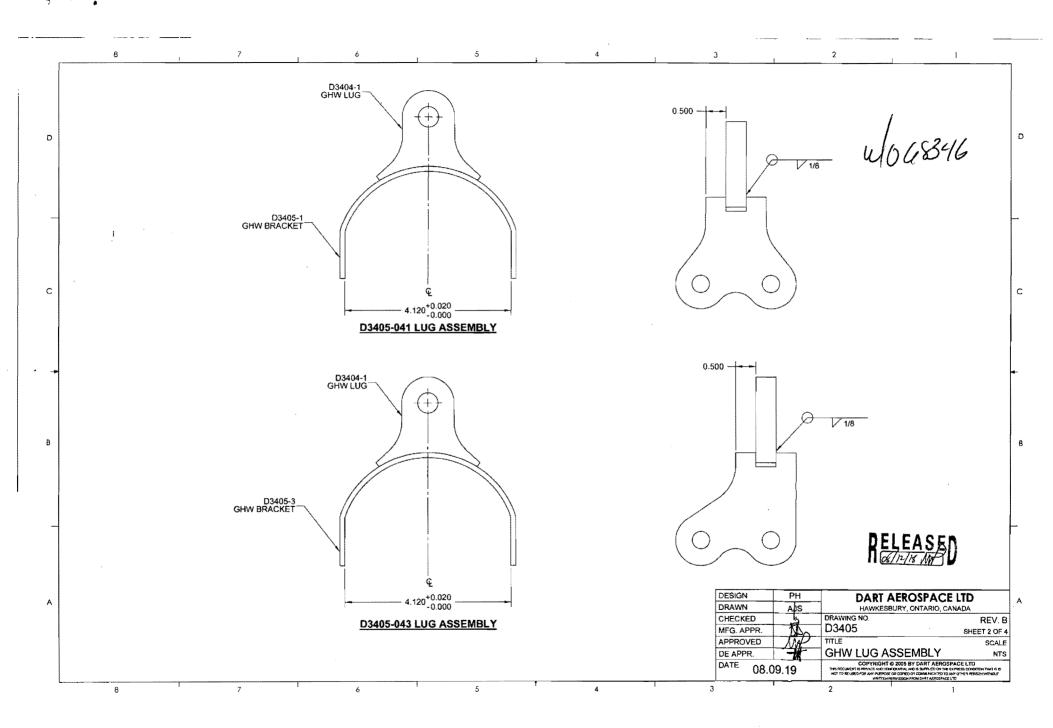
7) WEIGHT: -041, 0.85 lbs -043, 0.87 lbs

8

DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & 3 JINCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100. 08.09.19 AJS NEW ISSUE Α 05.03.08 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3405 MFG. APPR. SHEET 1 OF 4 APPROVED TITLE SCALE DE APPR. **GHW LUG ASSEMBLY** NTS COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS COCCUMENT IS PRIVATE AND COMPRISH AND IS SEPPLED ON THE SEPPLESS COMPI DATE 08.09.19

B

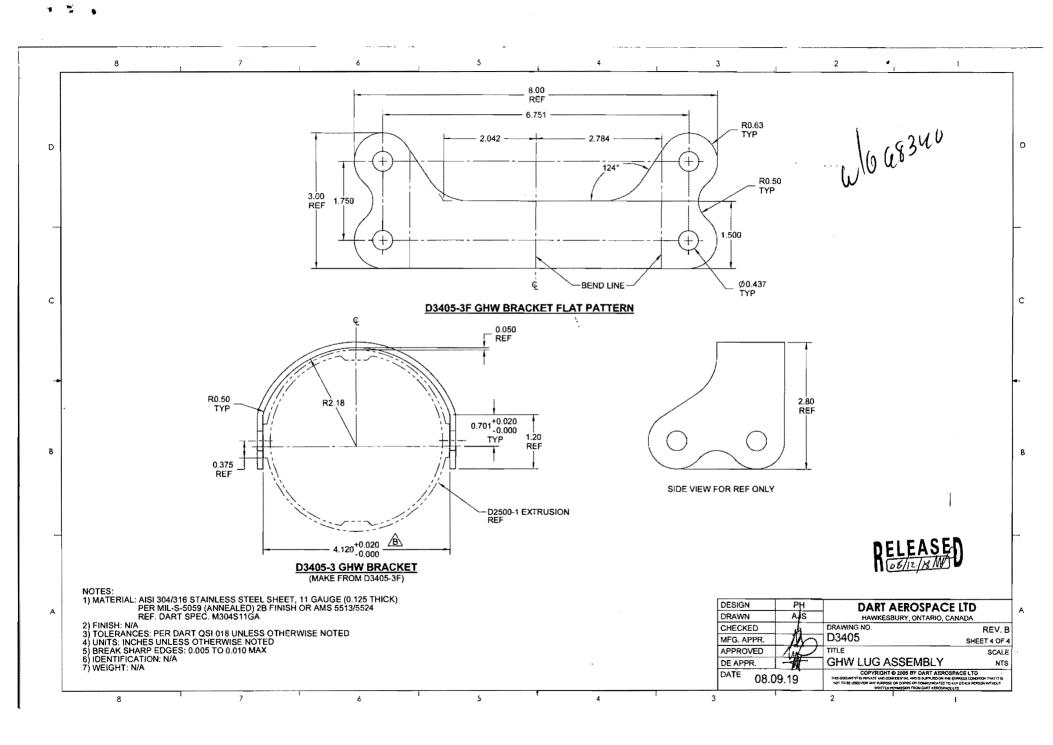
								•	
W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	By Date Qty				
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:	Date: _		
Resolution:			Dispositio	n:	_ QA: N/C C	A: N/C Closed: Date:			
NCR:		•	WORK ORD	ER NON-CONFORM	ANCE (NCF	₹)			
DATE	STEP	Description of NC		ion B	Verification	ion Approval	Approval		
DATE		SIEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
					•				



	•								•
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	By Date			Approval Chief Eng / Prod Mgr	Approval QC Inspector
					1				
		÷							
Part No	:	PAR #:	Fault Cat	degory:	NCR: Yes	No DQ	A :	Date;	
Resolution:			Disposit	_ QA: N/C Cld	QA: N/C Closed: Date: _				
NCR:			WORK ORI	DER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	Corrective Action Section			Verifi	cation	Approval	Approval
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC inspector
	1					1		1	1

2 8.00 REF ulo 68346 6.751 2.784 2 PL D D 2.197 2 PL R0.50 3.00 REF 1.750 1.50 Q R1.00 BEND LINE TYP Ø0.438 R0.63 TYP TYP С **D3405-1F GHW BRACKET FLAT PATTERN** 0.050 REF R0.50 2.80 TYP R2.18 REF 0.701+0.020 1.20 TYP REF 0.375 REF SIDE VIEW FOR REF ONLY D2500-1 EXTRUSION REF 4.120^{+0.020} B **D3405-1 GHW BRACKET** (MAKE FROM D3405-1F) NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A DRAWING NO. CHECKED REV. B D3405 MFG. APPR. SHEET 3 OF 4 TITLE APPROVED SCALE **GHW LUG ASSEMBLY** DE APPR. NTS COPYRIGHT & 2005 BY DART AEROSPACE LTD
THE DOZMARY OF SHORT A ARD SHAPLES OF THE SERVICES CO-DIT
THE DOZMARY OF SHORT A ARD SHAPLES OF THE SERVICES CO-DIT
THE DOZMARY OF SHAPLES OF THE SERVICES OF THE SERVI DATE 08.09.19 8

	•								€ 2 ₹	
W/O:			WO	RK ORDER CHAN	GES					
DATE	STEP	PRO	PROCEDURE CHANGE B		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
-										
Part No:		PAR #:	Fault Category: NCR: Yes No DQA:				A:	Date:		
Resolution:			Disposition: Q			QA: N/C Closed: Date: _				
NCR:		•	WORK ORDE	ER NON-CONFORM	MANCE (NC	R)				
DATE	STEP	Description of NC	Corrective Action Section E			Sign & Verification Section C			Approval	
		Secti	Section A	Initial Chief Eng	Action Description Chief Eng	n Sign Dat		Section C Chief	Chief Eng	g QC Inspector
									,	
•										



Dart Aerospace L	∟tc	
------------------	-----	--

W/O:			WO	RK ORDER CHAN	IGES						
DATE	STEP	PRO	PROCEDURE CHANGE By Date					Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			•								
						***************************************		i			
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes No DQA: Date:						
	Re	solution:	ıtion: Disposition:				•				
NCR:			WORK ORDE	R NON-CONFORI	MANCE (NCF	₹)					
BATE	0750	Description of NC	(ection B	Verific	cation	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng ¹	Action Description Chief Eng		Section C		Chief Eng	QC Inspector		
	·										
				·							